

# Work Order ID 54803

December 22, 2009 1:24:53 PM



Page 1

Item ID: D3700-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Inboard Window Doubler

Start Date: 1/04/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 09/12/23 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3700	Rev B

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3700 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Debur if necessary

B10-1-7



110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-1-7

120 0.00



QC8- Inspect parts - second check

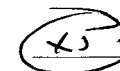
QC

Memo

0.00

Quality Control

⇒ 8106107



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54803**

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Item ID: D3700-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Inboard Window Doubler

Start Date: 1/04/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



HandFinish

Memo

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

BR 10-01-7

(5)

φ

140



QC

Memo

Quality Control

QC3- Inspect Part Finish

0.00

0.00

10-1-7

SP

150



Packaging

Memo

Packaging

Identify as per dwg &amp; Stock Location: 92

0.00

0.00

Puro/04(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54803**

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Item ID: D3700-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Inboard Window Doubler

Start Date: 1/04/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/08  
BS 10-1-08  
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 54803



Parent Item: D3700-1



Parent Item Name: Inboard Window Doubler

Start Date: 1/04/10

Required Date: 1/04/10

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No				sf	370.3809	1.1606	1.5		



6061-T6 .080 Sheet



18 10-1-7

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	370.38087	
110630	33.5136	
112141	0.86727	
113438	336	

113438

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





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 WORK ORDER  
 NO. 54803

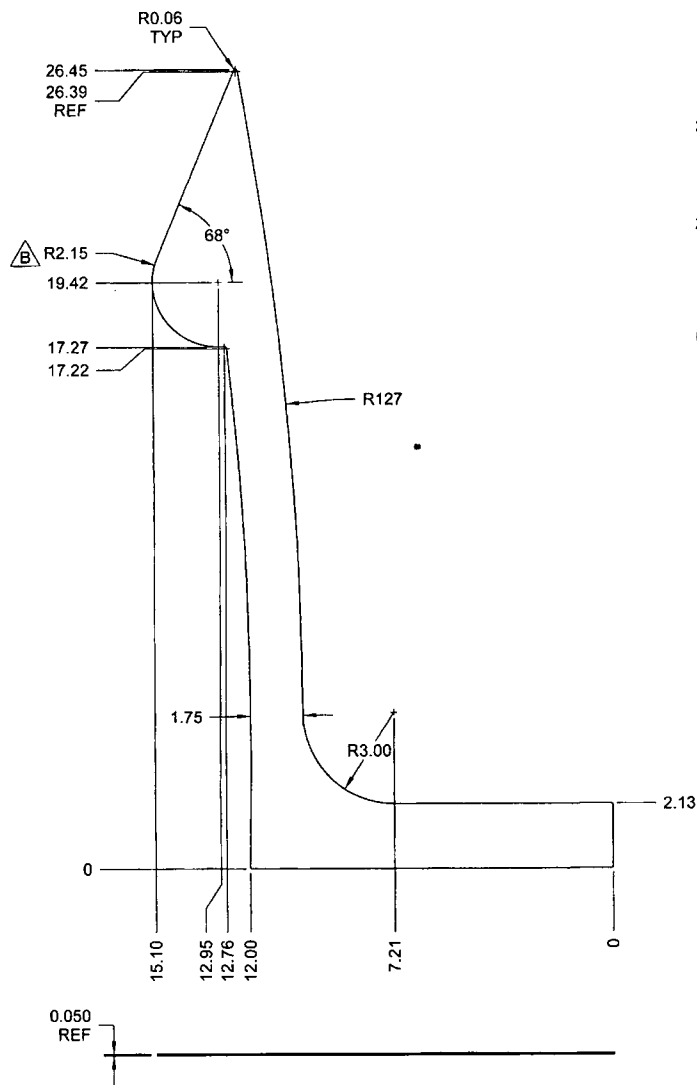
CZ09/12/23

D3700-1 INBOARD WINDOW DOUBLER

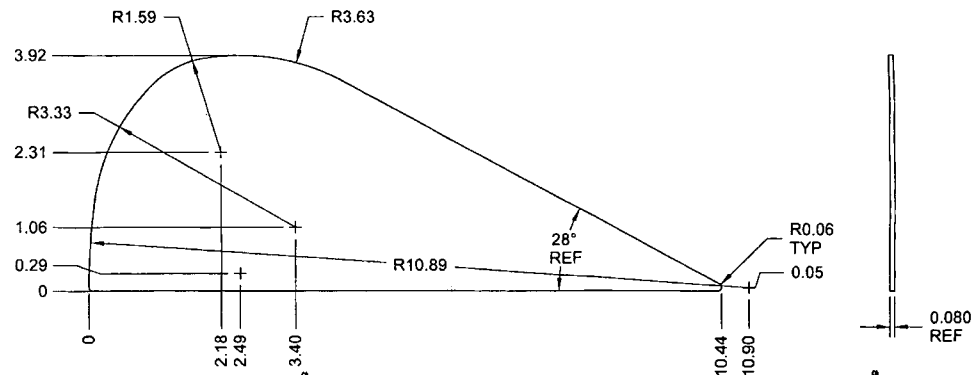
D3700-3 OUTBOARD WINDOW DOUBLER

RELEASED  
 09/04/09 NT

B	ADDED 0.25" TO TOP PROFILE OF D3700-3 (ZN D8-2). REDIMENSION PARTS; REMOVED REFERENCES TO DXF FILES (NOTES 8 AND 9).	MB	09.03.18
A	NEW ISSUE	MB	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3700	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW DOUBLER	NTS
DATE	09.03.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



**D3700-3 OUTBOARD WINDOW DOUBLER**



**D3700-1 INBOARD WINDOW DOUBLER**

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WITHOUT NOTICE  
WORK ORDER  
NO. 54803

**RELEASED**  
9/6/09

**NOTES:**

**1) MATERIAL:**

D3700-1: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)

D3700-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3700-X" USING FINE  
POINT PERMANENT INK MARKER  
7) WEIGHT: D3700-1 = 0.20 lbs  
D3700-3 = 0.37 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3700</b>	REV. B
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE <b>WINDOW DOUBLER</b>	SCALE NTS
DE APPR.			
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